

Date: Friday, 21/12/2007 2:45:27 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	36536		
Estimate Number :	10775		
P.O. Number :		Part Number :	D32081
This Issue :	21/12/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3208 REV A1
First Issue :	1/1	Project Number :	N/A
Previous Run :	32803	Drawing Revision :	A1
	Type :	Material :	
	MACHINED PARTS	Due Date :	18/01/2008
Written By :		Qty:	10
Checked & Approved By :		Um:	Each
Comment :	Est: B04.05.25 Material changed for Step 4KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1727 sf(s)/Unit Total : 1.7273 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)
 Note: To be made in multiples of 10
 Batch: *L1106272*

CP 08/01/16 (10)

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 4.038" X 5.340" grain along 4.038"
 Identify for D3208-1

CP 08/01/16 (10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Drill and Fillet D3208-1 corner as per Dwg D3208
 Identify as D3208-1

CP 08/01/17 (10)

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr D3208-1
 Form D3208-1 as per Dwg D3208
 Polish any marks on part within 01. of Dwg D3208

8/3 08/01/21

(P10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/01/22</u>	<u>4</u>	<u>1 part was out of tolerance at the set up</u> <u>Human error</u>	<u>[Signature]</u> <u>08/01/22</u>	<u>Swap & destroy</u> <u>no replace</u>	<u>SP</u> <u>08/01/22</u>	<u>[Signature]</u> <u>08-01-22</u>	<u>[Signature]</u> <u>08-01-22</u>	<u>[Signature]</u> <u>08-01-22</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36536

Part Number: D32081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/07 (9)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-01-24 (X9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

M-P 08/01/04

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57200*

Pc 8/01/25 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(9) 08/01/07

Job Completion



2008/11/28

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

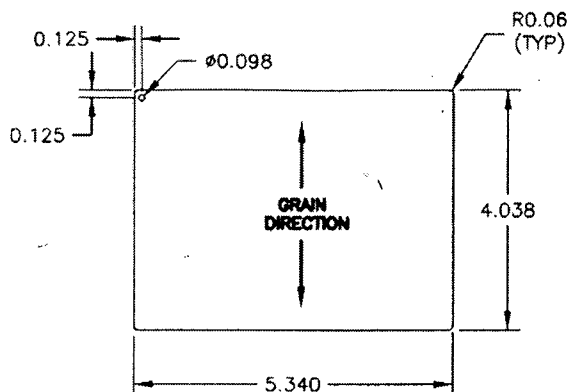
NOTE: Date & initial all entries



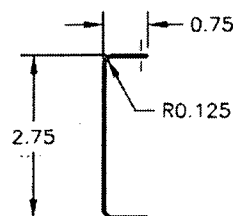
DESIGN JRT	DRAWN BY JRT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE DOUBLER		SCALE 1:3

RELEASED
04.09.05

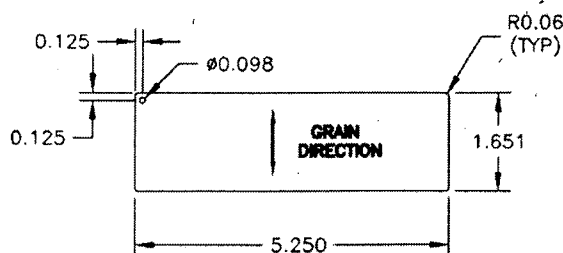
A	04.01.27	NEW ISSUE
A1	04.05.25	CHANGE DIM. NOTE 3) CHANGE



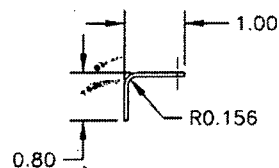
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)

W236536

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